



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

008602

647.7501

Job Sheet 190845



Part No: 647.7501

Job Qty: 2 pcs

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/19

Job Tracking No:

Due Date: 3/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	3/4/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

DPAS
228
99.89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S161694



Part: 647.7501

Job No: 190845

Serial No/Batch: S161694

Revision:

Inspector:

Exp Date:

Instructions:

Date: 03/12/19

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 36	
120	Small Fab - 2 - B4B	2 pcs	3/4/19	0.00 2.56	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	DAS
					Small Fab - 4 - B4B	36
					Small Fab - 5 - B4B	9-89
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
130	QC 5	2 pcs	3/4/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	MAR 21 2019 40
					QC 5 - 50	9-89
					QC 5 - 30	
					QC 5 - 30	
					QC 5 - 30	
140	Packaging 3-1 - Stock - B4B	2 pcs	3/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	Stool MAR 21 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	2 pcs	3/4/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAG
					QC 21 - SA - 53	21

MAR 21 2019

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

Descriptions: 130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015 CCK102	Blade	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	5136629
647.7601 65	Lower Deflector Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5141557
647.7810 77A	Bracket A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5115101
647.7811 77A	Bracket B	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5114668
647.7813 114	Center Plate, Lower	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5107255
647.7814 114	Fwd Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5112691
647.7815 122A	Fwd Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5113568
647.7816 122A	Aft Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5113471
647.7817 115	Aft Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5113838
MS21042L08 51303	Nut	26 Ea (13 ea)	110-Packaging 1 - Pick Kit	5134219
MS21042L3	Nut	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	5130347
MS27039-08-19	Screw	14 Ea (7 ea)	110-Packaging 1 - Pick Kit	5104359
MS27039-08-24	Screw (MS27039-0824)	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	5098209
MS27039-1-19	Screw	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	5155664
NAS1149F0332P	Washer	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	5157648
NAS1149FN832P	Washer	52 Ea (26 ea)	110-Packaging 1 - Pick Kit	5143716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3015	4	59	0
	647.7601	2	8	0
	647.7810	2	37	0
	647.7811	2	38	0
	647.7813	2	42	0
	647.7814	2	7	0
	647.7815	2	43	0
	647.7816	2	42	0
	647.7817	2	41	0
	MS21042L08	26	1,240	0
	MS21042L3	6	2,490	0
	MS27039-08-19	14	773	0
	MS27039-08-24	12	109	0
	MS27039-1-19	6	175	0
	NAS1149F0332P	12	2,640	0
	NAS1149FN832P	52	2,962	0

Part Specifications

Specifications could not be found.

Plex 2/19/19 8:02 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					